

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010419**Date Inspected:** 28-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (6AW)

This QA inspector performed Magnetic Particle Testing (MT) of the area previously tested and accepted by ABF Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Side panel 3AW to 3BW. The weld designations reviewed are as follows:

OBE3A-001 and 002 (Y locations: 3640, 6285)

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD**FCAW Process:**

Welding of weld joint -007 located on PCMK BK001-020, bike path cantilever. Welder is identified as 220067. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-Tc-U4b-F.

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SMAW Process:

Welding of weld joint –009 located on PCMK BK001-021, bike path cantilever. Welder is identified as 220069. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b.

OBG # TRIAL ASSEMBLY YARD (1AW-1BW)

SMAW Process:

Welding of weld joint –008 located on PCMK OBW1A, Bottom panel. Welder is identified as 067571. ZPMC CWI is identified as Li Yang. Welding was been performed against ABF Ultrasonic Report UT-1W-017R1. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1. (Y locations: 530, 3575, 5520)

OBG # TRIAL ASSEMBLY YARD (2AE-2BE)

This QA inspector witnessed Magnetic Particle Testing (MT) for deck panel to Edge panel connecting longitudinal weld (E2). MT was been performed by ABF Quality personnel. The weld designations are as follows:

CA100-002, 004 and 006

CA104-002, 004 and 006

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan
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Quality Assurance Inspector

Reviewed By:	Miller,Mark
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QA Reviewer
